

Work Order ID 105062

105062

Page 1

July-23-13 1:06:03 PM

Item ID: D350-600-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/26/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 13-07-24 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI9639

A

158

0.00

DAS
6
9-89

MAY 14 2015

100

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D350-600-241
CHG 001

1002 see attch document

0.00

110

110

Small Fab

Small Fab

Memo

1-Drill holes in D3188-1 using drill jig Dt8970
2-Open holes in D3188-1 body floor to 0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-1 as per dwg D3188

0.00

0.00

21,503-02

(H0) →

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

DAS
38
9-89

15-05-05

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: <u>105062</u> Part No. <u>D350-600-241</u> NCR No. _____				DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐ Equip/Tooling ☐ Operator ☐ Material ☐ Setup ☐ Other ☐ Process ☐ Supplier ☐ Training ☐ Unapproved ☐	15-03-02		x 2	damage to part on bottom Front inside corner + on inside bottom edge SEE ATTACHED DISPOSITION A.P. 15.04.20		Front inside corner: remove de-laminated mat'l repair as per QSI 037 section 9.3 inside bottom edge section 9.7 Hysol 934 B cloth in Epocast 80-41 B	[Signature] 				
FAULT CATEGORY <u>killed Fiber B</u>											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed R.H. Date: 15/06/20

Work Order: <u>105062</u> Part No: <u>D350-600-241</u> NCR No: <u>15-512</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☒	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	15.04.20	110	1	SCRAP WAS DROPPED ON ITS EDGE, CRACK & DELAMINATION IN THE AFFECTED ZONE. RC WAS FOUND IN BOX IN STAGING / MIS HANDLING OF PRODUCT	A.P. 15.04.20	REMOVE DELAMINATION & DAMAGED FIBERGLAS LAYERS. SCRAP BACK 0.5" PER FIBERGLAS PLY. COMPLETE REPAIR PER ACH3.13-113 SECTION 3.3 (a) ATTACHED. FILL VOID USING HYSOL 934 THICKED WITH MILLED FIBERS	[Signature] 15-04-20	DAS 38 9-89 15-05-05	[Signature] 15/05/05
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY Hysol 934 13158

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☒ Other <u>MIS HANDLING</u>

Work Order ID 105062

105062

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July-23-13 1:06:03 PM

Item ID: D350-600-241 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: SpacepodFwd Opening LH AS 350
 Start Date: 7/26/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/26/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

150

Small Fab

Memo

0.00

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y

1-drill and plug section I-I and J-J of dwg D3188 p. 11 using Hysol 934NA with
 milled glass fibres 10% to weight

A/R Hysol batch: 131561

xpiry date: 15-12-13

A/R Milled fibers batch: 100859

2-Attach Neoprene Foam using Contact cement

A/R Contact cement Batch: ~~_____~~

N/A Foam already
 attached as per 358597

45-05-05
 (P40) →

Perform work as
 per attach DSZ.
 5/15/26

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DAS

38

2-39

15-05-05

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AK Date: 15/06/30QA Closed: Date: 15/06/22

Work Order: <u>105062</u> Part No. <u>D350-600-241</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☒	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☒	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	15-02-26	130	x 1	install D5127-1 shim x 2 and D5127-3 shim x 2 as per DSI 9701 attached	5 15/02/26	old w/o not updated new w/o have been updated D5127-1 x 2 B 125150 D5127-3 x 2 B 125195	15-02-26	D350-600-241 FEB 26 2015	5 15/02/26
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☒ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Misabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Work Order ID 105062

July-23-13 1:06:03 PM

105062

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Item ID: D350-600-241

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/26/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

Wing Walk as per dwg QSI005 4.4 Batch 132039 0.00

170

HandFinish

Memo

0.00

Hand Finishing

15-05-05

180

QC3- Inspect Part Finish 0.00

180

QC

Memo

0.00

Quality Control

DAS

38

9-89

15-05-05

PTO

185

Pick Kit 0.00

185

Packaging

Memo

0.00

Packaging

1X 501505-6

DAS

28

9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: JSDate: 15/06/30QA Closed: JSDate: 15/06/23

Work Order: <u>105062</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D350-600-241</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-5/20</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☒	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	15-05-04	150	x1	Primer Flaking off in corners not properly scuffed before primer was initially applied	A.P.	2nd affected areas and Feather hard edge re prime	JS	DWG 33 9-03	5
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier				RC, Supplier issue.					
Training				* Raise NCR Against Delusick					
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved
☐ Heat Treat	☐ Countersink	☐ Mislabelled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	☐ Pressure/Forced
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	☐ Temperature/Cure
☐ Turning Sequence	☒ Finish	☐ Out of Sequence	☐ Weld
☐ Wave/Twist in Tube	☒ Folio	☐ Outside Dimensions	☐ Wrong Stock Pulled
			☐ Other

Work Order ID 105062

105062

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July-23-13 1:06:03 PM

Item ID: D350-600-241

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/26/13

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC4- 100% Inspect kits for completeness

0.00

DAS
6
9-89

MAY 14 2015

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 30

0.00

DAS
6
9-89

MAY 29 2015

200

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-141
Location: _____
PPP rev: _____

210

QC21- Final Inspection - Work Order Release

0.00

MLJ

JUN 08 2015

210

QC

Memo

0.00

Quality Control

MLJ

JUN 08 2015

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
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☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	
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July-23-13 1:06:01 PM

Required Qty: 1.00

Comments: IPP Rev:A07.03.07 new issue ec
IPP rev B 07.04.16 reformat,D3188 revE ec IPP Rev:C remove D3188-1m add
D3188-5 DD 10.04.07 verified by:JLM IPP rev D 10.04.19 removed hardware at seq 190
duplicated on K10021 EC verified by: DD IPP Rev:E remove seq 130/140 now
all in seq 150 DD 10.05.13 verf:EC IPP
REV:F 13.02.06 AS PER DS19639 REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2985 Label		Manufactured	No				Each	8.0000		1			
N/A 15.05.14													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST023		8							
					86719	8							
D2985-1 Decal, LH Install		Manufactured	No				Each	9.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST023		9							
					96951	9							
D3188-5 Spacepod Body		Manufactured	No			110	Each	0.0000	1	1		15-02-26	
D3186-3 Spacepod Door, LH		Manufactured	No			110	Each	0.0000	1	1		15-02-26	
D3187-1 Floor Panel		Manufactured	No			110	Each	8.0000	1	1		15-02-26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST241A		8							
				58597		1							
				59578		5							
				59578		2							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube ☐</td> <td style="width:25%;">Crosstube ☐</td> <td style="width:25%;">Water Jet ☐</td> <td style="width:25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐																								
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																								
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data ☐																											
Equip/Tooling ☐																											
Operator ☐																											
Material ☐																											
Setup ☐																											
Other ☐																											
Process ☐																											
Supplier ☐																											
Training ☐																											
Unapproved ☐																											

FAULT CATEGORY				
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions	☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	

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Work Order ID: 105062
 Parent Item: D350-600-241
 Parent Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13

Required Date: 7/26/13

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130
 Rivnut

Purchased No

128649

110

Each

5,891.0000

28

28

RT 15-02-26

Location	Loc Qty	Loc Code
FP001	389	
119084	116	
120671	89	
120807	36	
120837	8	
121269	140	
ST279	40	
124080	40	
st510	5462	
124163	1462	
M126109	4000	

A3235-020-935
 Washer - Countersunk

Purchased No

110

Each

243.0000

8

8

RT 15-02-26

Location	Loc Qty	Loc Code
ST278	243	
106150	243	

D2986-1
 Rubber Spacer

Manufactured No

150

Each

5.0000

1

1

x8

N/A as per B# 58597

DAS 02 9-89 JUN 08 2015

Location	Loc Qty	Loc Code
ST242	5	
99576	5	

D3015-3
 Locknut

Manufactured No

150

Each

135.0000

1

1

RT 15-05-04

130908

Location	Loc Qty	Loc Code
FG	10	
95758	8	
96151	2	
ST023	125	
95758	16	
97511	109	

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Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
---	---	---

☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	
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Picklist Print

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Page 3

Work Order ID: 105062

Parent Item: D350-600-241

Parent Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13

Required Date: 7/26/13

Start Qty: 1.00

Required Qty: 1.00

D3554-7 Manufactured No 37674 x 1 150 Each 47.0000 1 1 15-02-26

BALL STUD

Location	Loc Qty	Loc Code
FG	5	
87039	5	
ST056	42	
87039	12	
87571	30	

D3567-1 Manufactured No 150 Each 7.0000 1 1 15-02-26

Decal

Location	Loc Qty	Loc Code
ST058	7	
48254	7	

AN960JD516 NAS1149D0563J Purchased No 150 Each 2.0000 1 1 15-02-26

Washer

Location	Loc Qty	Loc Code
ST504	2	
1069059	2	

D2237 Manufactured No 150 Each 35.0000 2 2 15-02-26

Striker Plate

Location	Loc Qty	Loc Code
ST007	35	
93697	10	
96996	25	

MS20426AD4-5 Purchased No 150 Each 2,376.0000 4 4 15-02-26

RIVET

Location	Loc Qty	Loc Code
GA	5	
6874	5	
ST317	1371	
6874	1371	
ST334	1000	
m125807	1000	

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											
FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

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Work Order ID: 105062

Parent Item: D350-600-241

Parent Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13

Required Date: 7/26/13

Start Qty: 1.00

Required Qty: 1.00

D3538-1 Manufactured No
Hinge Bracket

12837-1

150 Each 16.0000 2 2 ET 15-02-26

Location	Loc Qty	Loc Code
FG	8	
84630	1	
91834	1	
94499	2	
98281	4	
ST056	8	
84630	1	
98281	7	

D2179 Manufactured No
Hinge Bracket Plate

150 Each 23.0000 2 2 ET 15-02-26

Location	Loc Qty	Loc Code
ST066	23	
35432	23	

AN526C832R24 Purchased No
screw

DAS 02 9-89
N/A
see Pto
JUN 08 2015

150 Each 130.0000 4 4 ET 15-02-26

Location	Loc Qty	Loc Code
ST346	130	
123850	64	
124255	66	

MS27039-08-11 Purchased No
SCREW

130358

150 Each 956.0000 2 2 ET 15-02-26

Location	Loc Qty	Loc Code
ST307	660	
122441	100	
123352	500	
123900	60	
ST308	296	
125654	296	

AN960JD8 Purchased No
Washer

NAS1149DN832J

131317

150 Each 0.0000 20 20 ET 15-02-26

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: JS Date: 15/06/22QA Closed: RPN Date: 15/06/22

Work Order: <u>105062</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D350-600-241</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>15-5119</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☒	Supplier ☐			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	15-05-05	170	x4	AN526 C832 R24 too short in location of D3536-1 hinge bracket R.C. DSI 9701 adds in shims but does not compensate screw length	W	use AN526 C832 R26 screws instead <u>M130875</u> x4	JS 15-05-05	DAE 30 9-09 15-05-05	DAE 20 0-09 15/05/05
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☒ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Misabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

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Work Order ID: 105062

Parent Item: D350-600-241

Parent Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13

Required Date: 7/26/13

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased

No

128635

150

Each

243.0000

2

2

ET 15-02-26

Washer

Location

Loc Qty

Loc Code

FG

4

123301

10

GA

3

124859

3

ST297

226

123301

7

125654

219

MS21042L08

Purchased

No

130725

150

Each

3,481.0000

18

18

ET 15-02-26

Nut

Location

Loc Qty

Loc Code

ST315

1481

122141

3

122452

9

122814

500

123900

969

ST505

2000

125445

2000

D2464

Manufactured

No

121946

150

f

452.2296

11.34

11.34

ET 15-05-05

Seal(\$per foot)

Location

Loc Qty

Loc Code

ST403

452.2296

61878

83.6406

83543

368.589

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Page 5

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data ☐												
Equip/Tooling ☐												
Operator ☐												
Material ☐												
Setup ☐												
Other ☐												
Process ☐												
Supplier ☐												
Training ☐												
Unapproved ☐												
FAULT CATEGORY												
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge 		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	

Picklist Print

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Work Order ID: 105062

Parent Item: D350-600-241

Parent Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13

Required Date: 7/26/13

Start Qty: 1.00

Required Qty: 1.00

D2586
Door Latch

Manufactured No

128416

150 Each 112.0000

2 2

BT 15-02-26

Location	Loc Qty	Loc Code
FG	11	
83893	10	
95760	1	
return2013	3	
xxxxx	3	
ST203A	98	
100607	98	

D2585
Latch Clamp

Manufactured No

127709

150 Each 56.0000

2 2

BT 15 02 26

Location	Loc Qty	Loc Code
ST012	56	
100527	26	
101805	25	
99063	5	

D2621
Latch Plate

Manufactured No

123542

150 Each 30.0000

2 2

BT 15-02-26

Location	Loc Qty	Loc Code
FG	2	
88616	2	
ST014	28	
88616	28	

MS27039-1-15
Screw

Purchased No

127916

150 Each 872.0000

2 2

BT 15 -02 26

Location	Loc Qty	Loc Code
ST506	872	
124326	872	

AN960JD10
WASHER

NAS1149D0363J

Purchased No

126319

150 Each 0.0000

2 2

BT 15-02-26

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
		☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Work Order ID: 105062

Parent Item: D350-600-241

Parent Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13

Required Date: 7/26/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

7,876.0000

2

2

Nut

131264

ST 15-02-26

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	3	
122141	3	
GA	18	
122452	18	
ST314	1367	
111668	1	
117885	32	
119017	55	
119075	138	
123265	43	
M126036	1098	
ST506	1488	
123900	912	
124291	576	
ST510a	5000	
M126275	1000	
M126333	4000	

D2857-1

Manufactured

No

150

Each

32.0000

1

1

Hinge Bracket

120387

ST 15-02-26

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
82261	4	
91914	1	
ST019	27	
100965	24	
91914	1	
95859	2	

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Misabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Picklist Print

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Work Order ID: 105062

Parent Item: D350-600-241

Parent Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13

Required Date: 7/26/13

Start Qty: 1.00

Required Qty: 1.00

D2857-2	Manufactured	No	114154	150	Each	37.0000	1	1	8T 15-02-26
Hinge Bracket									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	3	
78904	3	
ST019	34	
100769	24	
95712	10	

D2228	Manufactured	No	95704	150	Each	23.0000	4	4	8T 15-02-26
Backing Plate									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST007	23	
73380	23	

AN526C832R10	Purchased	No		150	Each	139.0000	10	10	8T 15-02-26
Screw									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST345	139	
118853	39	
123831	100	

D3557-1	Manufactured	No		150	Each	14.0000	1	1	8T 15-02-26
BRACKET									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST058	14	
73384	14	

AN526C832R14	Purchased	No		150	Each	473.0000	2	2	8T 15-02-26
Screw									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST346	473	
124215	473	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
---	---	---

☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other	
--	---	--

7x842

Picklist Print

July-23-13 1:06:03 PM

Page 9

Work Order ID: 105062

Parent Item: D350-600-241

Start Date: 7/26/13

Required Date: 7/26/13

Parent Item Name: SpacepodFwd Opening LH AS 350

Start Qty: 1.00

Required Qty: 1.00

K10021
Spacepod Hardware (-241)

DAS
6
9-89

Manufactured No

185 Each 2.0000

1 1

DAS

Location

Loc Qty

Loc Code

FG125 ✓

2

B128936

1

27

DAS

9-89

28

9-89

93820

2

D350-600-449
Switch Relocation

DAS
6
9-89

Manufactured No

185 Each 2.0000

1 1

DAS

Location

Loc Qty

Loc Code

FG125 ✓

2

B229789

1

27

9-89

MAY 06 2015

79288

1

94572

1

D2985
Label

DAS
6
9-89

Manufactured No

185 Each 8.0000

1 1

Location

Loc Qty

Loc Code

S1023

8

5T01486719

8

B104787

SP 15-05-6

OK
15.05.14

DAS
28
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											

FAULT CATEGORY									
Landing Gear			General						
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced					
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure					
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld					
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled					
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved						
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong						
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other					
☐ Ripples in Bend	☐ Drill Holes	☐ Offset							
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration							
☐ Turning Sequence	☐ Finish	☐ Out of Sequence							
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions							

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-600 REV. E OR EARLIER

AND ICA-D350-600 REV. 5 OR EARLIER

REF TCCA STC: SH93-88

REF FAA STC: SR00098NY/SR00099NY

REF EASA STC: EASA.IM.R.S.01292

1.0 PURPOSE:

IT HAS COME TO DART'S ATTENTION THAT THE INFORMATION SHOWN ON D2985 DECAL CAN BE MISINTERPRETED WHEN ONLY A LH OR RH SPACEPOD IS INSTALLED ON AN AIRCRAFT. THEREFORE, THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO ADD THE D2985-1/-3 DECALS AS OUTLINED BELOW.

2.0 INSTRUCTIONS:

IT IS ACCEPTABLE TO REPLACE D2985 WITH D2985-1/-3 AS FOLLOWS:

D2985-1: FOR LH INSTALLATIONS ONLY (REF. D35X-600-141/-143/-241/-243)

D2985-3: FOR RH INSTALLATIONS ONLY (REF. D35X-600-142/-242)

3.0 PARTS LIST

QTY -141	QTY -142	QTY -143	QTY -241	QTY -242	QTY -243	PART NUMBER	DESCRIPTION
X						D350-600-141	SPACEPOD _™ LH, AS350
	X					D350-600-142	SPACEPOD _™ LH, AS350/AS355
		X				D355-600-143	SPACEPOD _™ LH, AS355
			X			D350-600-241	SPACEPOD _™ LH, AS350
				X		D350-600-242	SPACEPOD _™ LH, AS350/355
					X	D355-600-243	SPACEPOD _™ LH, AS355

1	1	1	1	1	1	D2985	DECAL
1		1	1		1	D2985-1	LH DECAL (ADD)
	1			1		D2985-3	RH DECAL (ADD)

4.0 WEIGHT AND BALANCE

NO CHANGE.

5.0 MAINTENANCE:

MAINTAIN D2985-1/-3 PER ITEM 5.2.7 OF ICA-D350-600.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.12.07
CERT. NO.: SH93-88
ISSUE NO.: 6

12-20-01
13-07-24
105062 MLS

A	NEW ISSUE	SFM	12.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SFM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9639	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DECAL CHANGE	NTS
DATE	12.12.04	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/8816 OR DERA KANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

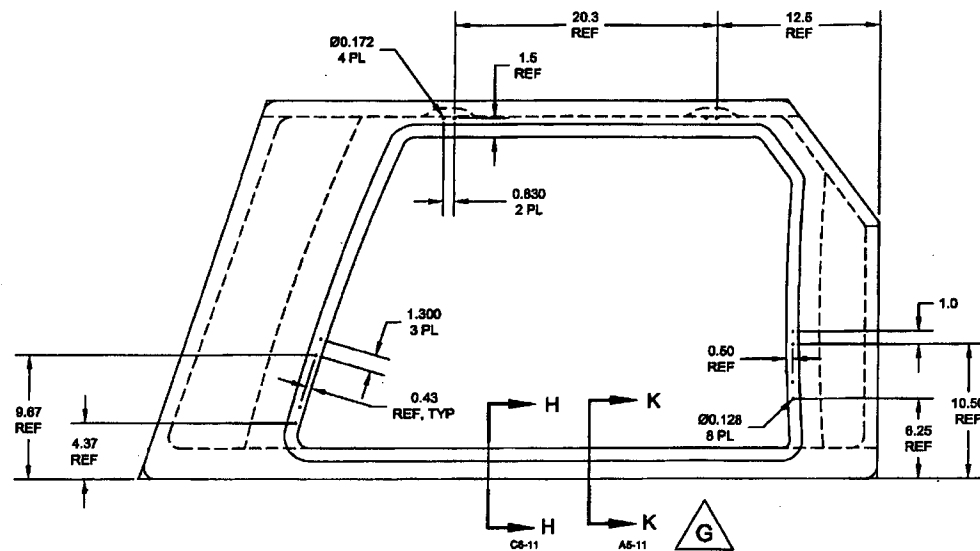
1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M-1/-5	DT8003	DT8501
D3188-2M-2/-6	DT8004	DT8502
D3188-3M-3/-7	DT8500	DT8501

- 2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A
- 8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 10) POT INSERTS PER QSI 006 SECTION 4.16

RELEASED
2014-07-28

G	ADD SECTION K-K/L-L: INSERT INSTALLATION TO SHEET 11 (ZN A5-11)	DB	14.06.20
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0800-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M-2M-3M-6/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	JB	DRAWING NO.	REV. G
MFG. APPR.	JB	D3188	SHEET 1 OF 11
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DE APPR.	JB	SPACEPOD BODY	NTS
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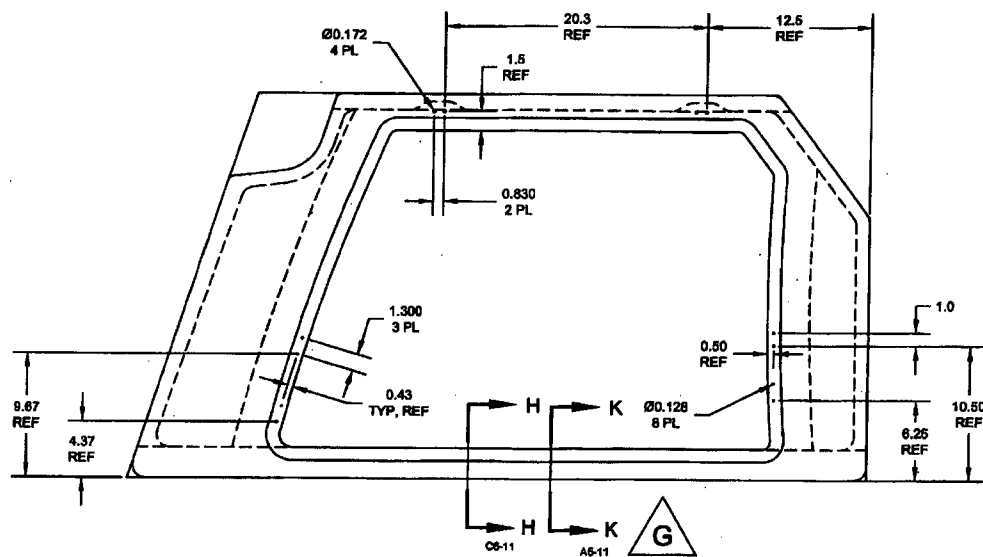
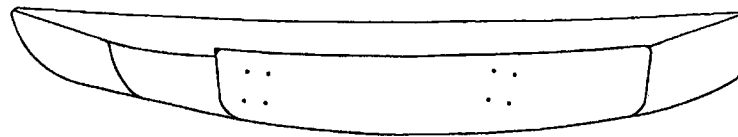
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2014-07-28

D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
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MFG. APPR.		D3188	SHEET 2 OF 11
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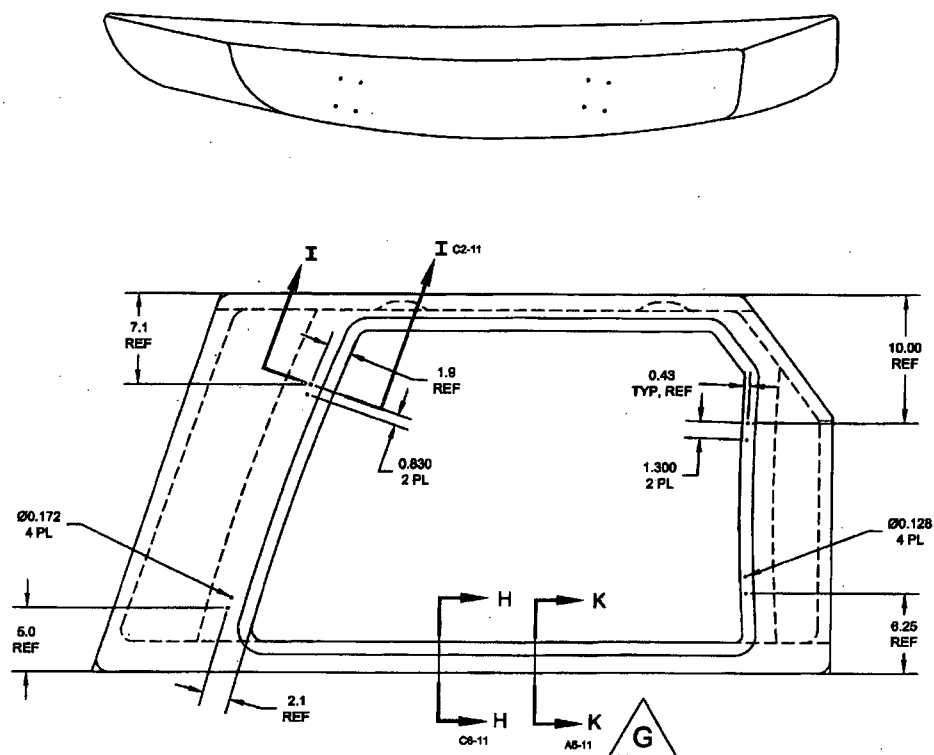
D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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MFG. APPR.		D3188	SHEET 4 OF 11
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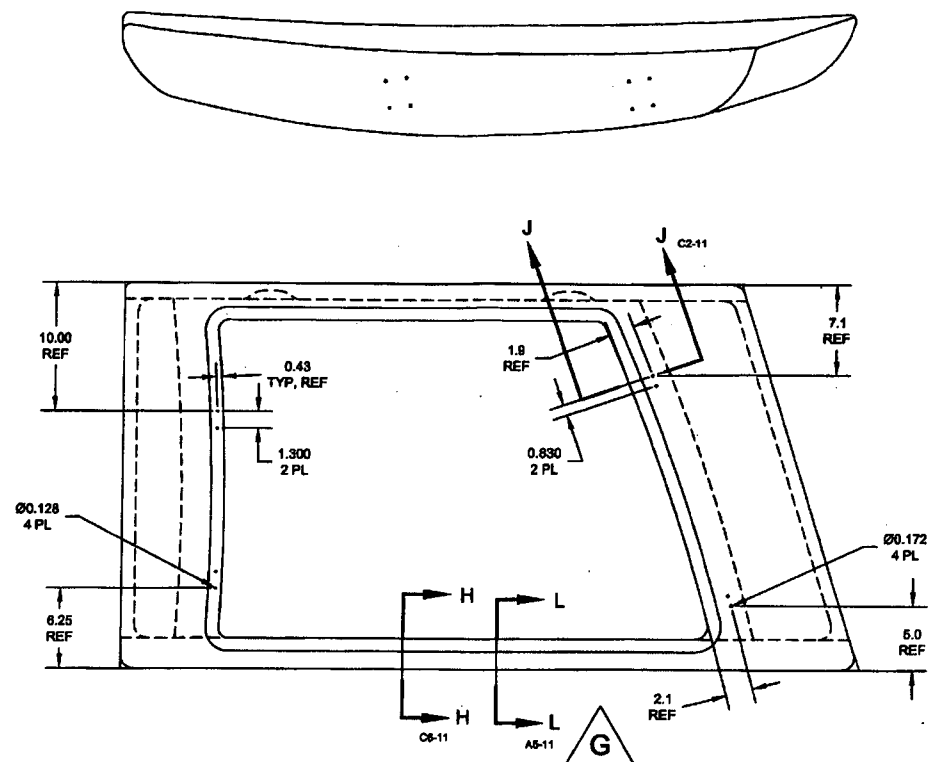
D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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MFG. APPR.		D3188	SHEET 5 OF 11
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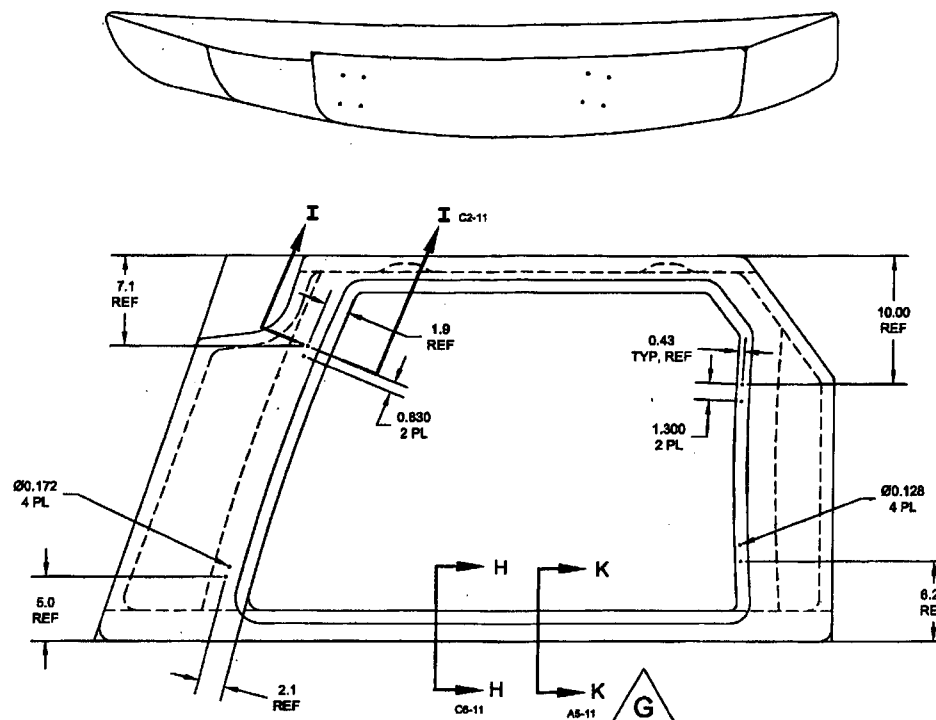
D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 6 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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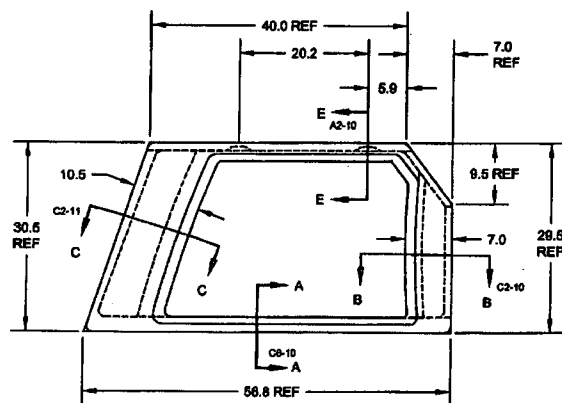
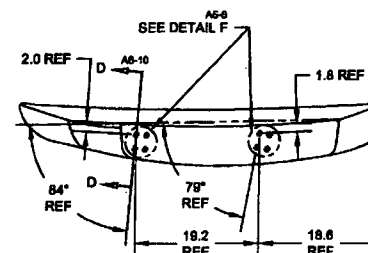
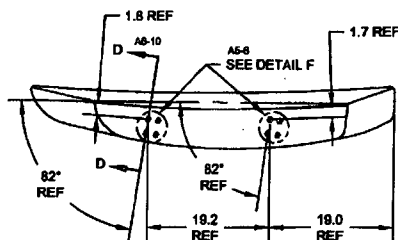


D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

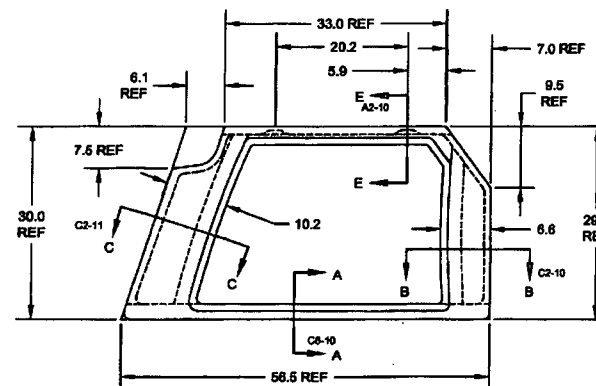
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2014-07-28

NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

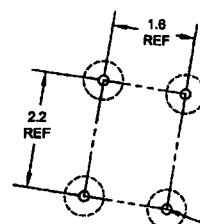
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DRAWN	DB		
CHECKED	AS	DRAWING NO.	REV. G
MFG. APPR.	MS	D3188	SHEET 7 OF 11
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F

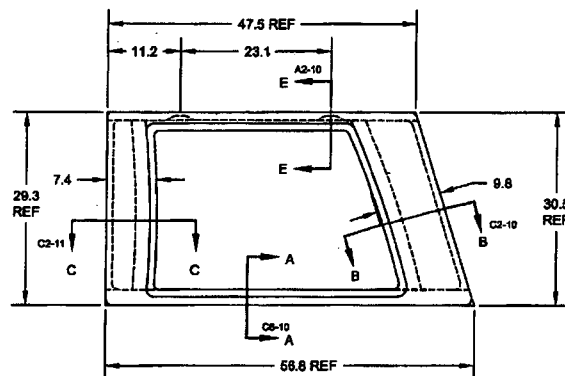
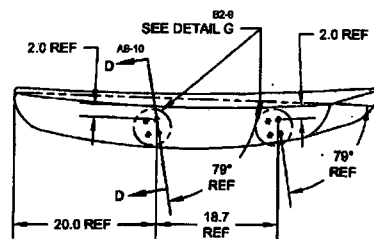
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

D3188-1M/-3M NOTES:

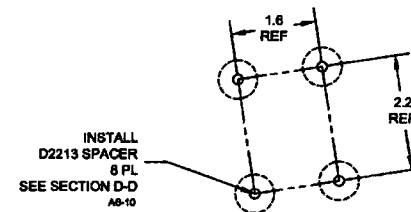
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

RELEASED
2014-07-28

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
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D3186-2M SPACEPOD BODY



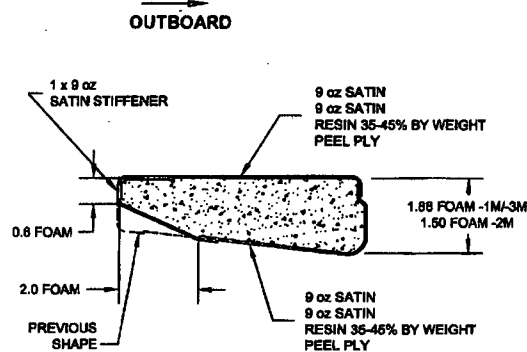
DETAIL G D6-9

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2014-07-28

D3186-2M NOTES:

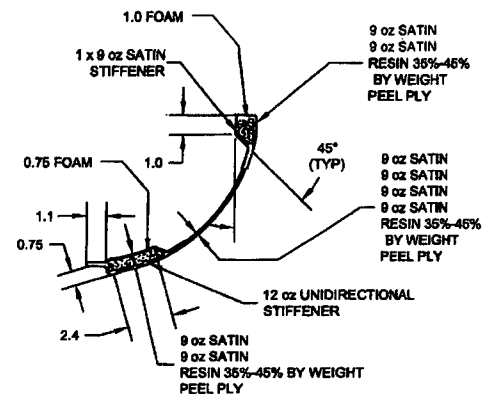
- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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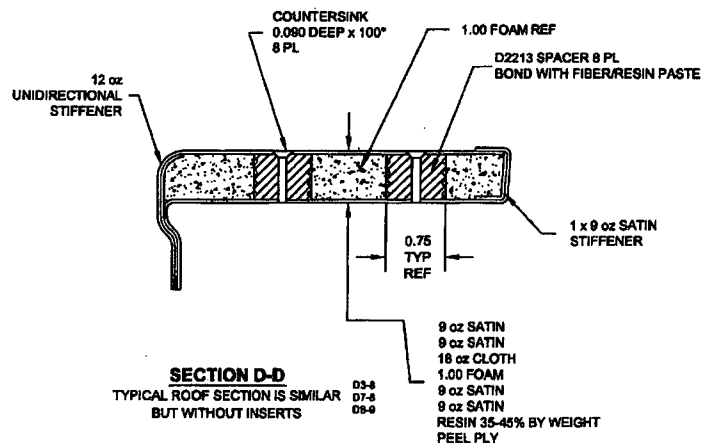
SECTION A-A
TYPICAL FLOOR SECTION

B7-6
B3-6
B6-6



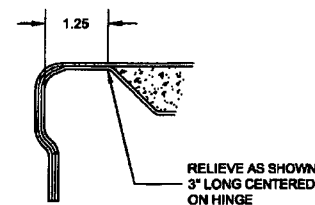
SECTION B-B
SECTION C-C OPPOSITE

B6-6
B8-6
B4-6
B3-6
B7-6
B5-6



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS

D3-6
D7-6
D9-6



SECTION E-E
2 PLACES PER POD

C3-6
C7-6
B6-6

RELEASED
2014-07-28

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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8 7 6 5 4 3 2 1

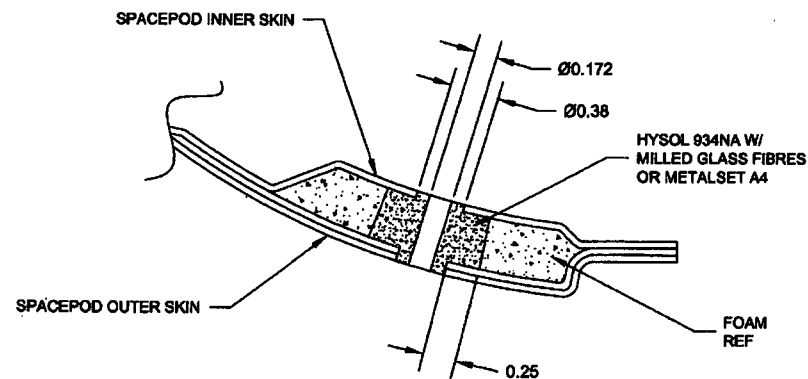
OUTBOARD

INSTALL AKS7-1032-130
INSERTS 29 PL
PER D3188-1T1 (D3188-1/3/5/7)
OR D3188-2T1 (D3188-2/6)
TO ALIGN WITH HOLES IN D3187-1/2 FLOORS



SECTION H-H
TYPICAL FLOOR SECTION

A6-2
A6-3
A6-4
A6-6
B6-6
B6-7



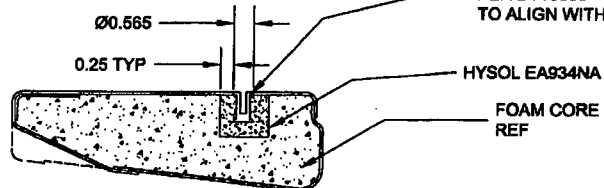
SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

C6-6
C4-6
C6-7

OUTBOARD

10

INSTALL 80-005-2-10
INSERTS 7 PL
PER DT10068
TO ALIGN WITH HOLES IN D3187-1/2 FLOORS



SECTION K-K
SECTION L-L OPPOSITE
TYPICAL FLOOR SECTION

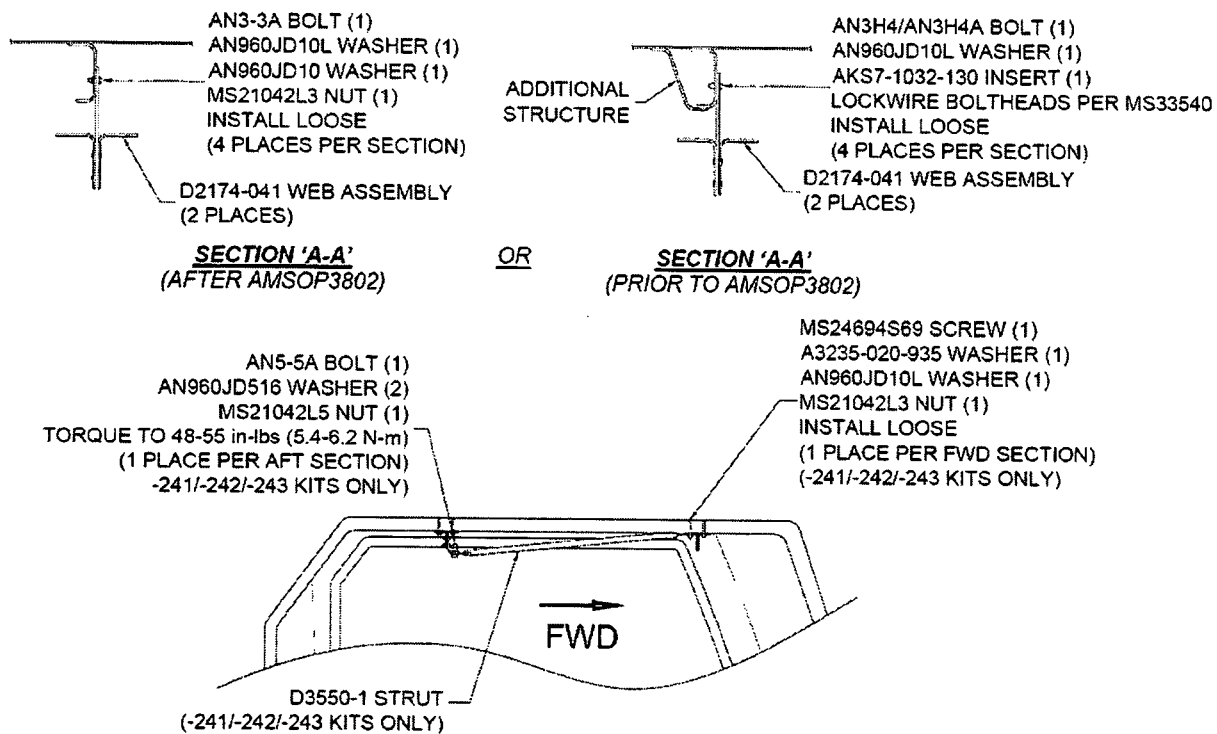
B4-2
B5-3
B4-4
B4-5
B4-6
B4-7

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2014-07-28

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	JB	DRAWING NO. D3188	REV. G SHEET 11 OF 11
MFG. APPR.	JB	TITLE SPACEPOD BODY	SCALE NTS
DE APPR.	JB	DATE 14.06.20	

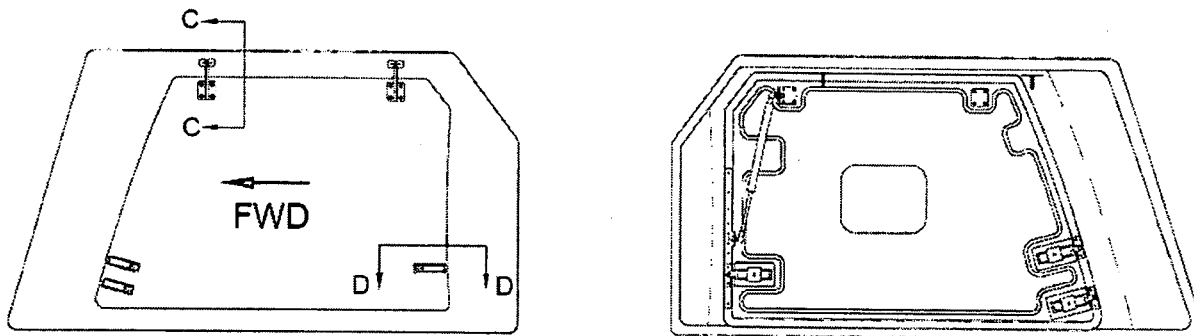
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8 7 6 5 4 3 2 1

**SECTION 'B-B' STRUT INSTALLATION**

3.2.10 Tighten the floor and web assembly fasteners. Torque to 15-25 in-lbs.

3.2.11 Re-install the D3186-1/-2/-3/-4 Spacepod™ door by connecting the hinges as shown Figure 6. Install the D3552-7/-3 gas spring rod end down on the ball studs. Ensure that the latches are closing the door tightly and securely; adjust the latches as necessary as shown in Figure 6.



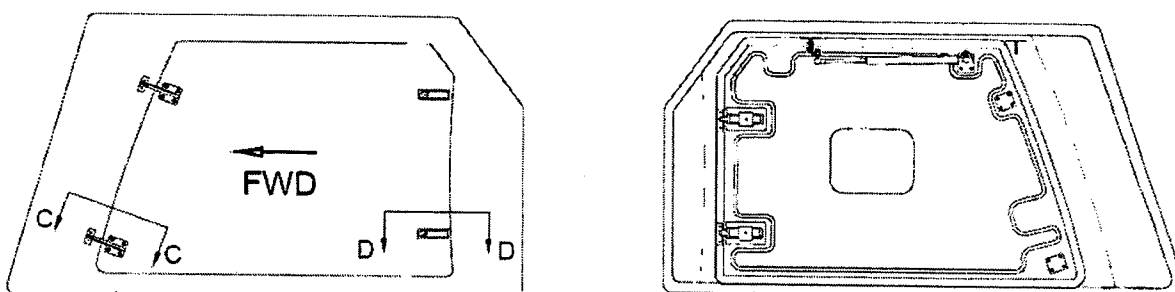
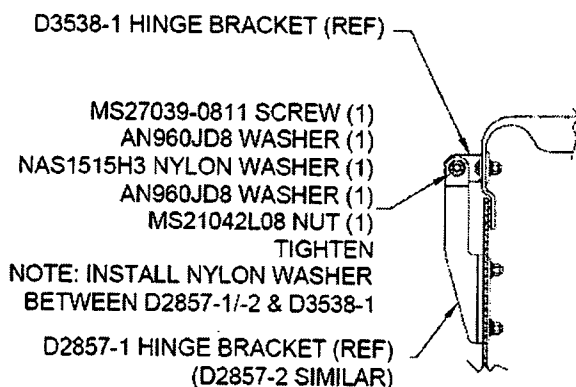
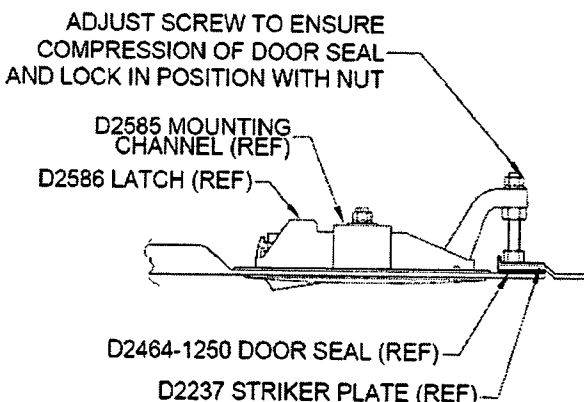


FIGURE 6(b) – -241 SPACEPOD™ KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



SECTION 'C-C' HINGE

(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



SECTION 'D-D' LATCH

- 3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:
 - a. Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
 - b. If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
 - c. Re-install the belly panel per the Aircraft Maintenance Manual.
- 3.2.13 Relocate the forward door-open switch using the D350-600-349/-449 Door Switch Relocation Kit in accordance with Section 3.6 of this IIN.
- 3.2.14 Re-install the cargo restraining system per Section 4.0 of this IIN.
- 3.2.15 Complete any other maintenance required prior to returning to service.
- 3.2.16 Install the D2985 decal on a clearly visible area of the instrument panel.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-600 REV E AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-600 REV 5

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY and SR00099NY
REF. EASA STC EASA.IM.R.S.01292

1.0 PURPOSE

In response to customer feedback, Dart is implementing changes designed to ease the mounting of hinge brackets for the forward opening Spacepod and to improve the security of the hinge assemblies. The purpose of this DSI is to introduce the DSI 9701-011 Hinge Shim Kit and to provide instructions and parts lists to install and assemble the hinges on Dart Spacepods D350-600-241/-242/-243/-247/-248/-249. One Kit is required per door.

2.0 PROCEDURE

- 2.1 Remove the D3186-3/-4 Spacepod Door by disconnecting the hinges.
- 2.2 Remove the D3538-1 Hinge Brackets and D2179 Hinge Bracket Plates. Retain all parts.
- 2.3 Re-install the D3538-1 Hinge Brackets with the D5127-3 Shims between the Spacepod and Hinge Bracket using the existing mounting holes and fasteners. See Figure 1. The D3538-1 Hinge Brackets should be oriented as per Table 1. It may be necessary to reverse the orientation, as required, on some Spacepod bodies. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.4 Torque fasteners to 9-12 In-lbs (1-1.4 N-m).

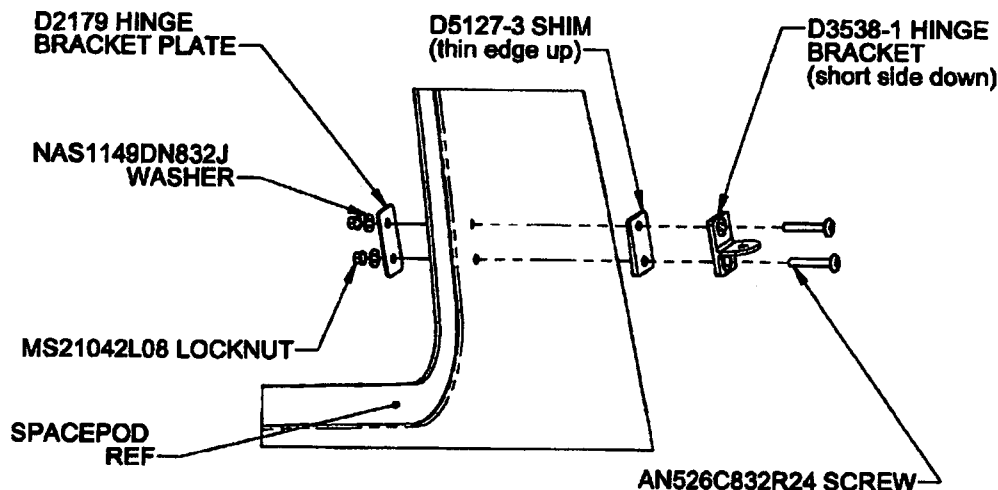


FIGURE 1: SPACEPOD HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

SPACEPOD	UPPER D3538-1 BRACKET	LOWER D3538-1 BRACKET
RIGHT SIDE	SHORT SIDE UP	SHORT SIDE DOWN
LEFT SIDE	SHORT SIDE DOWN	SHORT SIDE UP

TABLE 1: D3538-1 HINGE ORIENTATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

B	ADD NOTES ALLOWING USE OF ADDITIONAL SHIM MATERIALS, ALTERNATE SHIM ORIENTATION	DB	14.09.09
A	NEW ISSUE	DB	14.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9701	SHEET 1 OF 3
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DE APPR.		HINGE SHIM KIT	NTS
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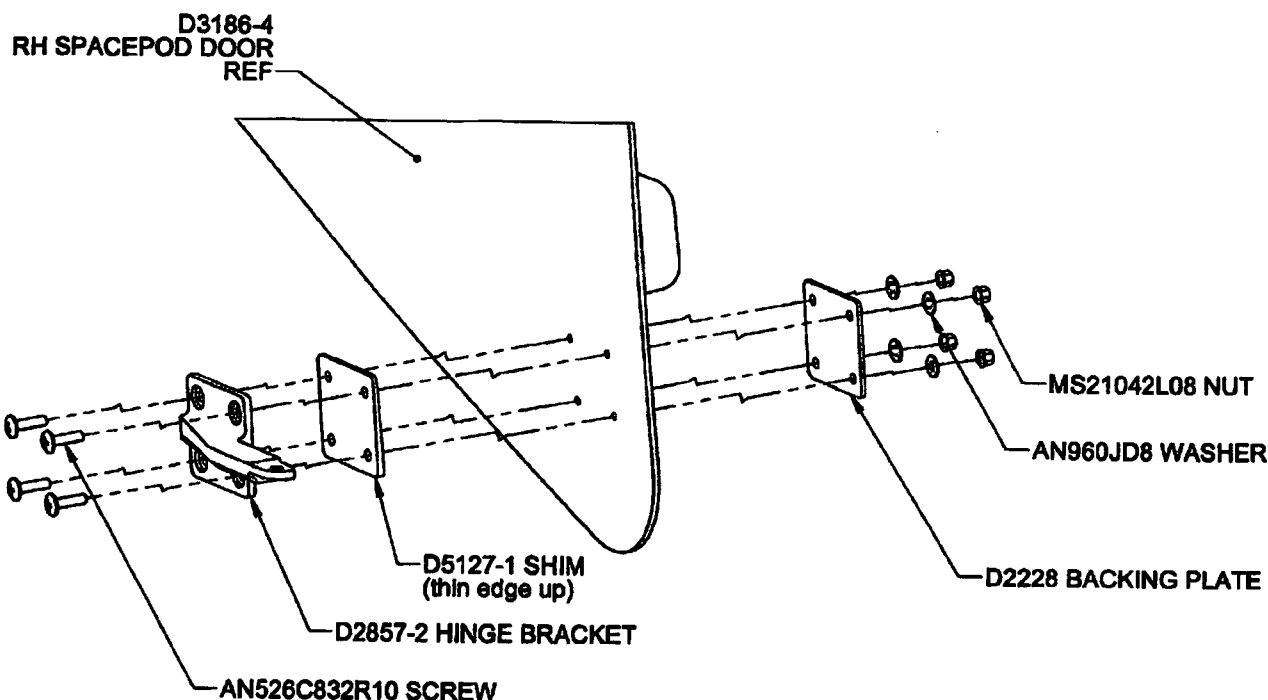


FIGURE 2: SPACEPOD DOOR HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

- 2.5 Remove the D2857-1/2 Hinge Brackets and D2228 Backing Plates. Retain all parts and fasteners.
- 2.6 Re-install the D2857-1/2 Hinge Brackets with the D5127-1 Shim between the Spacepod Door and Hinge Brackets, using the existing mounting holes and fasteners. See Figure 2. The hinge brackets should be installed as shown in Table 2. Shims can be re-oriented, as required, to provide the best mounting configuration. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.7 Torque fasteners to 9-12 in-lbs (1-1.4 N-m).
- 2.8 Re-install the D3186-3/4 Spacepod Door onto the Spacepod per Section 52.4 of ICA-D350-600. See Figure 3 for reference.

DOOR	UPPER HINGE BRACKET	LOWER HINGE BRACKET
RIGHT SIDE	D2857-1	D2857-2
LEFT SIDE	D2857-2	D2857-1

TABLE 2: HINGE SELECTION CHART

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9701	REV. B
MFG. APPR.	N/A	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE HINGE SHIM KIT	SCALE NTS
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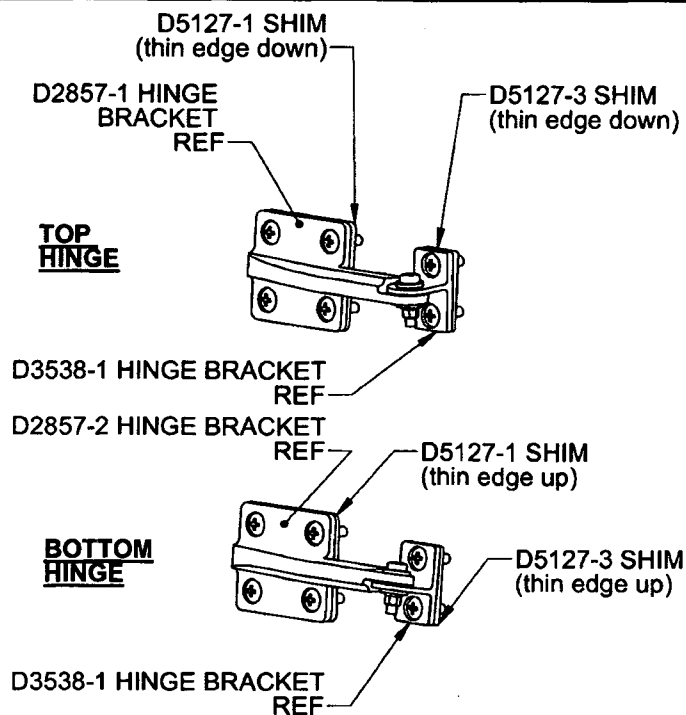


FIGURE 3: DSI 9701-011 HINGE KIT ASSY
(RH DOOR ASSY SHOWN, LH OPPOSITE)

3.0 PARTS LIST

QTY -011	P/N	DESCRIPTION
X	DSI 9701-011	HINGE SHIM KIT
2	D5127-1	SHIM, LARGE
2	D5127-3	SHIM, SMALL

4.0 WEIGHT AND BALANCE

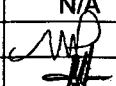
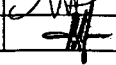
There is no Weight and Balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

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MFG. APPR.	N/A	DSI 9701	SHEET 3 OF 3
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Work Order ID 105062

105062

Page 1

July-23-13 1:06:03 PM

Item ID: D350-600-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: SpacepodFwd Opening LH AS 350

Start Date: 7/26/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/26/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-07-24 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI9639

A

100

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-600-241

CHG 001

see attachment

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-1 using drill jig Dt8970

2-Open holes in D3188-1 body floor to 0.297" as per dwg D3188

3-Deburr

4-Install inserts in D3188-1 as per dwg D3188

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

MAY 06 2015

MAY 06 2015

15-03-02
P10

15-05-05

Change Record

PAGE 1 OF 1

Part Number: D350-600-241/-242/-243

Description: SPACEPOD, LH, AS 350 / RH, AS 350/355 / LH/RH, AS 355

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐	